	er ID 114977 17, 2014 2:33:51 PM		*114	977*							Page 1
	D3457-1		Accept	*N900	040	100) *	Setup	Start	*NI	S1*
Revision ID: Item Name:	Washer	``							Stop		S2*
Start Date:	4/04/14 Start Qty: 24.00	*24*		Cust Item I	D:						,
Required Date:	4/04/14 Req'd Qty: 24.00	*24*		Customer:							
Reference:				i							
Approvals:	Process Plan:	Date: 14-03-18	Tooling:	Da	ite:			Run	Start	~1V	R1*
	QC:	Date:	SPC (Y/N):	Da	ite:				Stop	*N	R2*
Sequence ID/ Work Center II	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	t Rej Qty		Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr				_						<u> </u>
D3457	Rev A										ORS A
100			0.00					-			•
100	DOOSAN LATHE						24	_ Ø			14-3-21
Doosan Doosan Lathe	Memo Turn as per l	Folio FA589 Rev: <u>A A</u> &	0.00 Dwg D3457 Rev: <u>A</u>								٠
¹¹⁰ *11∩ *	QC2- Inspect parts off m	achine FAJ/FAJB	0.00				2 Y	đ	ζ		DAS 13 9-89

^11()⁶ QC

Memo

0.00

Quality Control

120

QC8- Inspect parts - second check

0.00

DAS 44 14 103/21 9-89

120

Memo

0.00

24 &

Quality Control

DQA:		Date:	:											TRAC
QA Closed:		Date:	:		WORK ORDER NON-	-CC	ONFO	RMANCE / UF		Wo	ork Order up	odate only	٦	AEROSPACE
					DISPOSITION						PARTMENT			
Work Orde	er:													
Part N	Part No.			Rework Scrap Use-as-is	· — ·		Skid-tube Crosstube Machining Small Fab Thermoforming Finishing				Water Jet d. Eng. Coor. e/Packaging	- En	gineering Quality Other	
NCR N	10		· · · · · · · · · · · · · · · · · · ·		Suspected Unapproved			Large Fab	Composite			Supplier		
Root				Desci	ription of work order update		Initial	Acti	ion		Sign &			
Cause	Da	te Step	Qty		or non-conformance	Ch	nief Eng	Descri	iption		Date	Verification		QC Inspector
Design														
Doc/Data														
Equip/Tooling			l								•			
Handling/Pre														
Material				<u> </u>		İ								
Operator														
Offset/Setup				•										
Process														
Supplier														
Training														
Transport			Ì			l								
Unapproved						l								
						FA	ULT CA	TEGORY						
Landi	ng Gear				General				_					
	Bend	ing			Bend		Folio/F	rogram			Outside Dim	ensions	Press	sure/Forced
	Centi	e Not Conce	entric		BOM/Route		Grain		ĺ		Over/Under	tolerance	Set-	up
	Crack	S			Broken/Damage/Defect		Hardwa	ire	ĺ		Part Incorred	:i	Tem	perature/Cure
	Crim	o/Kink/Ripple	e/Wave		Burrs		Inspect	ion Incomplete/Un	qualified		Part Lost/Mi	ssing	Weld	1
	Cuffs				Contamination		Instruct	tions Incomplete/U	Inclear		Part Moved	Γ	Wro	ng Stock Pulled
	Crush	ing			Countersink		Misalig	ned/off center			Positioned V	ے Vrong		
	Heat	Treat			Cut Too Short		Mislabe	eled			Power Loss/	Surge	Othe	er
	Inspe	ction Strip ir	n Tube		Drawing	Γ	Misread	d	•		•			
	Mark	s/Chatter			Drill Holes		Off-set							
	Turni	ng Sequence	9		Finish		Out of	Calibration						
	Wave	/Twist in Tu	be		Fit/Function		Out of s	Sequence						

114977

Page 2

Monday, March 17, 2014 2:33:51 PM Accept Item ID: D3457-1 *N900040100* Setup Start **Revision ID:** Stop Item Name: Washer *24* Start Date: 4/04/14 **Start Otv: 24.00 Cust Item ID:** Required Date: 4/04/14 Rea'd Otv: 24.00 *94* **Customer:** Reference: Start Run Process Plan: Date: Tooling: **Approvals:** Date: Stop OC: Date: SPC (Y/N): Date: Operation Tool ID Sequence ID/ Set Up/ Tool # Plan Accept Reject Reject Insp. Work Center ID Description Otv Otv Number Stamp Run Hours Code Identify as per dwg & Stock Location: 570H/o 130 0.00 24x 28 14-03-21 *120* Packaging 0.00 Memo Packaging 140 OC21- Final Inspection - Work Order Release 0.00 MLJ 14-03-24 MLJ 14-03-21 *140* OC 0.00 Memo Quality Control

DQA:		Date:			DAR									TRAG
QA Closed:		Date:			WORK ORDER NON-	-CC	ONFO	RMANCE / UI		Wa	ork Order up	ndate only	¬	AEROSPACE
Q/ Closed.				,				-			•	• [
Work Orde	er:				DISPOSITION				AGAINST	ST DEPARTMENT/PROCESS				
					Rework			Skid-tube	Crosstube			Water Jet	T Er	ngineering
Part N	lo.				Scrap			Machining	Small Fab		Pro	d. Eng. Coor.	7	Quality
					Use-as-is		Therr	noforming	Finishing		Rec/Stor	re/Packaging		Other
NCR N	10				Suspected Unapproved			Large Fab	Composite			Supplier		
Post				Dosc	ription of work order update	نــــ	Initial	Act	ion		Sign &			
Root Cause	Da	te Step	Qty	Desci	or non-conformance		nief Eng		iption		Date	Verification		QC Inspector
Design	Da	ie step	Qty	<u> </u>	or non-comormance		ilei Elig	Desci	траоп		Dute	Vermeation	+	QC IIISPECTOI
Doc/Data														
Equip/Tooling														
Handling/Pre								,						
Material														ļ
Operator														
Offset/Setup											i			
Process		İ												:
Supplier														
Training														
Transport														
Unapproved						<u> </u>					<u> </u>			
						FA	ULT CA	regory						
Landi	ng Gear				General	_	1		1		1		\neg _	
	Bend	•		-	Bend	<u> </u>	4	Program			Outside Dim	—		ssure/Forced
	_	e Not Conce	entric		BOM/Route	⊢	Grain				Over/Under	F	⊢ Set	•
	Crack			<u> </u>	Broken/Damage/Defect	<u> </u>	Hardwa				Part Incorred	· · · .		nperature/Cure
		o/Kink/Rippl	e/Wave	\vdash	Burrs	-	1 '	ion Incomplete/Ur	-		Part Lost/Mi	ssing	We	
	Cuffs			-	Countarink	<u> </u>	4	tions Incomplete/U	unciear		Part Moved	L	wro	ong Stock Pulled
	Crush	iing Treat		\vdash	Countersink Cut Too Short	\vdash	Mislabe	gned/off center		-	Positioned V	_	٦٨٠	
	$oldsymbol{\vdash}$	rreat ction Strip i	a Tubo	-	Drawing	-	Misrea			<u> </u>	Power Loss/	ourge	Oth	let
	⊢	s/Chatter	ilube	-	Drill Holes	\vdash	Off-set						P*************************************	
		ng Sequence	a	-	Finish	\vdash	4	Calibration						
		e/Twist in Tu		<u> </u>	Fit/Function	\vdash	4	Sequence						
	1 1	., I u			1	1	10000							

Monday, March 17, 2014 2:33:50 PM

Work Order ID: 114977

114977

Parent Item:

D3457-1

D3457-1

Parent Item Name: Washer

Start Date: 4/04/14

Required Date: 4/04/14

Start Qty: 24.00

Required Qty: 24.00

Comments:

IPP A05.10.03New issueKJ/JLM

IPP Rev:B Now on Doosan Lathe 08-10-30 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELRINR1.000		Purchased	No			100	f	16.1142	0.0208	1			Φ
MDFI RII	VR1 000)					ļ		**		14-3.	-20	DAS 13

Delrin Round Bar 1"

Location Loc Qty Loc Code **MAT039** 16.11421 m127442 16.11421

DQA:			Date:										`	TQAC [~]
QA Closed:			Date:			WORK ORDER NON-	-CC	ONFO	RMANCE / UPD		ork Order up	data only		AEROSPACE
QA Closed.			Date.							····	ork Order up	date only		
Work Orde	r:					DISPOSITION				AGAINST D	EPARTMENT,	/PROCESS		
						Rework			Skid-tube	Crosstube	7	Water Jet		Engineering
Part N	ο.					Scrap		(Machining	Small Fab	Pro	d. Eng. Coor.	\neg	Quality
						Use-as-is		Thern	noforming	Finishing	Rec/Stor	e/Packaging		Other
NCR N	lo					Suspected Unapproved			Large Fab C	Composite		Supplier		
Root					Desc	ription of work order update		nitial	Action	1	Sign &		丁	
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descript	ion	Date	Verification	٦	QC Inspector
Design														
Doc/Data									,		1			
Equip/Tooling	_													
Handling/Pre	_		·										-	
Material	4												1	
Operator	_													
Offset/Setup	4													
Process	_								₹7					
Supplier	4								Ì					
Training	_											•		
Transport										•			İ	
Unapproved			<u> </u>	l	l		FAI	UTCAT	FCORY					
Landin						General	FA	ULI CA	TEGORY					
Lanuin		ending			Γ	Bend	Г		Program		Outside Dim	onsions [一,	Pressure/Forced
-		_	ot Concer	ntric	-	BOM/Route	┝	Grain	Togram	-	Over/Under		\dashv	Set-up
	\neg	Cracks	or concer	11.10	\vdash	Broken/Damage/Defect	\vdash	Hardwa	ıre	-	Part Incorred	F	\neg	Temperature/Cure
	⊣		nk/Ripple	/Wave	\vdash	Burrs	-	1	ion Incomplete/Unqu	alified	Part Lost/Mi		\neg	Weld
		Cuffs		,		Contamination		1 .	ions Incomplete/Unc	├	Part Moved	331118	_	Wrong Stock Pulled
	-	Crushing				Countersink	\vdash	4	ned/off center	_	Positioned V	L √rong	`	The otook i when
	_	leat Trea	nt			Cut Too Short		Mislabe	•	-	Power Loss/		\neg_{c}	Other
	_		n Strip in	Tube		Drawing	Г	Misread		<u> </u>	_	. O		
	_	Marks/Ch	•			Drill Holes	\vdash	Off-set			•			
	_		equence			Finish		-	Calibration					
ı İ	\neg \	Nave/Tw	ist in Tub)e		Fit/Function		Out of	Seguence		-			. <u> </u>

DART AEROSPACE LTD	Work Order:	114977
Description: Washer	Part Number:	D3457-1
Inspection Dwg: D3457 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article	Prototype
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Drawing	Tolerance	Actual	Accept	Reject	Method of	Comments
Dimension	7 313141133	Dimension	, tooopt	110,000	Inspection	
R1.575	+/-0.010	R.1.575				
0.030 x 0.030	+/-0.010	-03 x.038				
0.530	+/-0.010	.526	/			
0.063	+/-0.010	.064				
0.169	+/-0.010	.165				
Ø0.655	+/-0.010	.656				
Ø1.000	+/-0.010	-95%				
		10				
			1			
			-			
*****	,			,		
,						

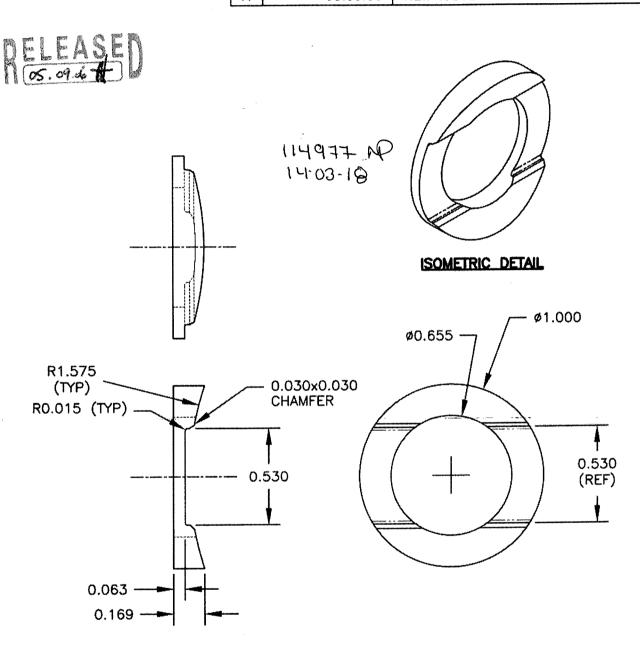
9 _ D	DAS		
Measured by:	Audited by: 44	Prototype Approval:	N/A
Date: / 4-3-20	Date: 14/03/21	Date:	N/A

Rev	Date	Change	Revised by	Approved_
Α	08.11.28	New Issue	KJ/EC	<i>X</i>



1969 50113011

DESIG	° CP	DRAWN BY CP	DART	AEROSPACE PORT HADLOCK,	
CHEC	KED M	APPROVED A	DRAWING NO.		REV. A
	#	#	D3457		SHEET 1 OF 1
DATE		A	TILE		SCALE
05.0	9.06		WASHER		2:1
A		05.09.06	NEW ISSU	JE	



D3457-1_WASHER

- 1) MATERIAL: DELRIN (DART SPEC. M-DELRIN-R)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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